

# Work Order ID 81699

May-10-12 7:44:47 AM

*Double Rush*  
\*81699\*

Page 1

Item ID: D3764-1

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Back Leg Fitting

Start Date: 3/29/12 Start Qty: 6.00

\*6\*

Cust Item ID:

Required Date: 3/29/12 Req'd Qty: 6.00

\*6\*

Customer:

Reference:

Run Start \*NR1\*

Approvals:

Process Plan: *W*

Date:

Tooling:

Date:

Stop \*NR2\*

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3764

Rev B

100

0.00

\*100\*

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blank .295" long

*SL 12/05/13*

*6*

110

0.00

\*110\*

HAAS CNC VERTICAL MACHINING #1

HAAS I

Memo

0.00

HAAS CNC vertical machine #1

1- Mill as per Folio FA741 Rev: *AA* & Dwg D3764 Rev: *B* 2-Deburr  
per dwg D3764

*SL 12/05/13*

*6*

120

QC2- Inspect parts off machine FAI/FAIB

0.00

\*120\*

QC

Memo

0.00

Quality Control

*SL 12-05-13*

*6*

# Work Order ID 81699

**\*81699\***

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May-10-12 7:44:47 AM

Item ID: D3764-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Back Leg Fitting  
 Start Date: 3/29/12 Start Qty: 6.00 **\*6\*** Cust Item ID:  
 Required Date: 3/29/12 Req'd Qty: 6.00 **\*6\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 <b>*130*</b> QC Quality Control	QC8- Inspect parts - second check  Memo	0.00  0.00		and 12/05/13 1		6	0		
140 <b>*140*</b> HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00  0.00							⑥ 7/6 12-5-14
150 <b>*150*</b> QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00				6			1 2/05/14

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**\*81699\***

**Item ID:** D3764-1

Revision ID:

**Item Name:** Back Leg Fitting

**Start Date:** 3/29/12      **Start Qty:** 6.00

**Required Date:** 3/29/12      **Req'd Qty:** 6.00

**Reference:**

**Approvals:** \_\_\_\_\_ **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Setup Start \*NS1\*

Stop \*NS2\*

Run Start \*NR1\*

Stop **\*NR2\***

[illegible]

ME  
12-05-14

# Picklist Print

May-10-12 7:44:47 AM

Page 1

Work Order ID: 81699

Parent Item: D3764-1

Parent Item Name: Back Leg Fitting

Start Date: 3/29/12

Required Date: 3/29/12

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 08-05-01 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.500X02.000 6061-T6 Bar 1.50 x 2.00		Purchased	No			100	f	15.4577	0.25	1.5789474 <u>1.538'</u>		<u>12/05/11</u>	

Location

Loc Qty

Loc Code

MAT004

15.45768

114608

0.05768

✓ 117933

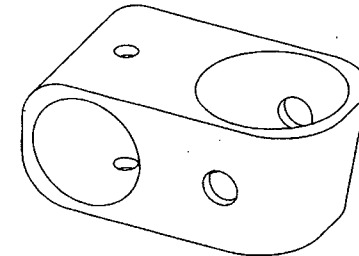
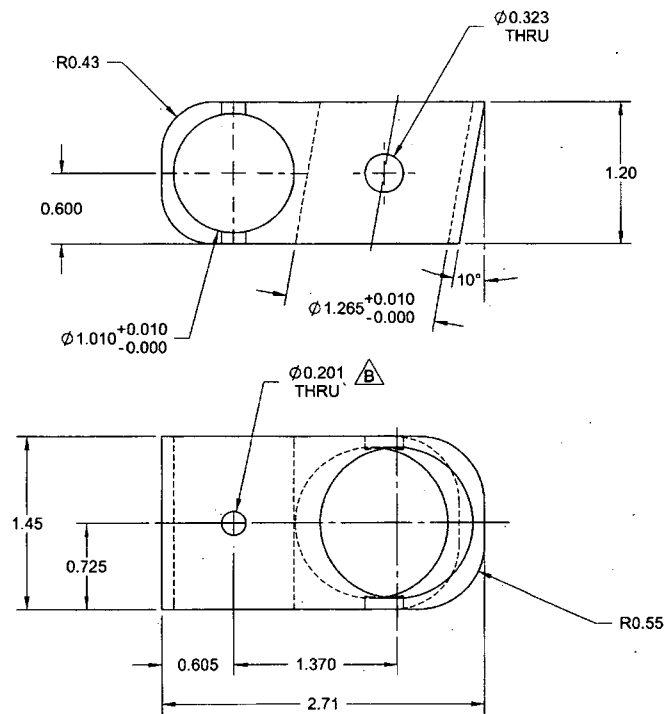
3.4

119231

12

1.538'





**D3764-1 BACK LEG FITTING**

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) PER AMS-QQ-A-200/8 (OR AMS 4160) (REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.13 lbs

B	CHANGE HOLE SIZE TO 0.201	HS	08.06.10
A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED	<i>[Signature]</i>	DRAWING NO. <b>D3764</b>	
MFG. APPR.	<i>[Signature]</i>	REV. B SHEET 1 OF 1	
APPROVED	<i>[Signature]</i>	TITLE <b>BACK LEG FITTING</b>	
DE APPR.	<i>[Signature]</i>	SCALE NTS	
DATE	08.06.10	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD  THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

634  
-101

